



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4838-1

Job Sheet 166819



Part No: D4838-1

Job Qty: 10 ea

Part Name: Upper Cutter Body, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/17/17

Job Tracking No:

Due Date: 11/5/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	10 Ea		11/3/17	0.00	0.00	Start up container	
100	Bandsaw	10 pcs		11/3/17	0.00	0.05	Bandsaw1	
110	CNC Vertical Machining	10 pcs		11/5/17	0.58	17.54	HAAS 1	
120	QC	10 pcs		11/5/17	0.00	0.00	QC2	
130	QC	10 pcs		11/5/17	0.00	0.00	QC8	
140	Outsource	10 pcs		11/5/17	0.00	0.00	Outsource4	
150	Packaging	10 pcs		11/5/17	0.00	0.00	Packaging2	
155	QC	10 pcs		11/5/17	0.00	0.00	QC5	
170	QC	10 pcs		11/5/17	0.00	0.00	QC14	
180	Packaging	10 pcs		11/5/17	0.00	0.00	Packaging3	
190	QC21-SA	10 Ea		11/5/17	0.00	0.00	QC21	

Part Op 100 - Cut Blank at 4.500"

Descriptions: 110 - 1-Machine per folio FB190

140 - Issue P/O: _____ Black Anodize as per Dwg D4838

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B1.000X7.000	4	5	0	0

Part Specifications

Specifications could not be found.

Plex 10/17/17 1:12 PM dart.Michaud-Febrille.Victoria

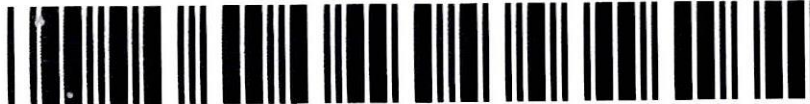
7X 4.5
3X 4.5
Trove OK

B#M134164-172.625
B#M133659 1.125
5025167



Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Upper Cutter Body, LH

PART NO: D4838-1
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/19/17

Job No: 166819



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Upper Cutter Body, LH

PART NO: D4838-1
Original Serial #: S025170
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/19/17

Job No: 166819

DART AEROSPACE LTD		Work Order:	
Description: Upper Cutter Body, LH		Part Number:	D4838-1
Inspection Dwg: D4838	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.130 x 45°	+/-0.030 x +/-0.5°	0.130x45°	V		Ver	ED-6
4.18	+/-0.030	4.179	V		Ver	ED-6
7.03	+/-0.030	7.027	V		Ver	ENG02
0.60	+/-0.030	0.597	V		Ver	ED-6
0.74	+/-0.030	0.743	V		Ver	ED-6
1.40	+/-0.030	1.400	V		Ver	ED-6
2.44	+/-0.030	2.44	V		Ver	ED-6
R0.25	+/-0.030	R0.25	V		R.G.	
23.7°	+/-0.5°	23.7°	V		D.A.G.	
30.2°	+/-0.5°	30.2°	V		D.A.G.	
0.168	+0.003/-0.000	0.169	V		Depth geo.	KT-04
0.263	+0.002/-0.003	0.262	V		Ver	ED-6
0.272	+/-0.010	0.272	V		Ver	ED-6
6.625	+/-0.010	6.625	V		Ver	CAX-02
6.250	+/-0.010	6.251	V		Ver	CAX-02
4.167	+/-0.010	4.168	V		Ver	ED-6
1.883	+/-0.010	1.884	V		Ver	ED-6
Ø0.177	+0.005/-0.001	0.177	V		G.P.	
0.400	+/-0.010	0.401	V		Ver	ED-6
0.360	+/-0.010	0.360	V		Ver	ED-6
4.560	+/-0.010	4.562	V		Ver	ED-6
2.110	+/-0.010	2.110	V		Ver	ED-6
2.400	+/-0.010	2.401	V		Ver	ED-6

Measured by: SC	Checked by: JN	QC Inspector:
Date: 7/12/29	Date: 18/01/03	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.06.23	New Issue	KJ	41



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914458

Date: 22-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: D4838-1 Upper Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22310	Rev: A PO: PO038727 Line: 20	
1 ea	Part: D4838-2 Upper Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22311	Rev: A PO: PO038727 Line: 21	
17 ea	Part: D4838-2 Upper Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22312	Rev: A PO: PO038727 Line: 22	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/1/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038727

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18	169361	646.9813	Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C Lower Deflector Low Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.9800 Rev. A	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$11.85/pcs	\$142.20
19	169288	646.9910	Struts Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	1/30/17	25 pcs	0 pcs	25 pcs	\$14.10/pcs	\$352.50
20	166819	D4838-1	Upper Cutter Body, LH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-1 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$10.95/pcs	\$109.50
21	166821	D4838-2	Upper Cutter Body, RH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed	1/30/17	1 pcs	0 pcs	1 pcs	\$10.95/pcs	\$10.95
22	166822	D4838-2	Upper Cutter Body, RH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed	1/30/17	17 pcs	0 pcs	17 pcs	\$10.95/pcs	\$186.15
23	169560	SWA6A-800A	Connector Bushing -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	1/30/17	6 pcs	0 pcs	6 pcs	\$3.10/pcs	\$18.60
24	169654	SWA6A-700	Wire Clamp -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$7.45/pcs	\$89.40
25	169600	RBT18538-1	Left Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$14.58/pcs	\$29.16

D4838-2
Job Sheet 166821

Tel (613) 632-5200

Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

DART
AEROSPACE



Part No: D4838-2
Part Name: Upper Cutter Body, RH

Job Qty: 10 ea
Status: Scheduled
Job Tracking No:
Created By: Victoria Michaud-Febrille
Description:
Part Weight: 0 lbs
Job Created: 10/17/17
Due Date: 11/1/17
Type: Stock
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Setup Run		Worker/Supplier
					hrs	Hrs	
90	Start up Operation	10 Ea	10/31/17		0.00	0.00	Start up container
100	Bandsaw	10 pcs	10/31/17		0.00	0.03	Bandsaw1
110	CNC Vertical Machining	10 pcs	11/1/17		0.80	14.08	HAAS 1
120	QC	10 pcs	11/1/17		0.00	0.00	QC2
130	QC	10 pcs	11/1/17		0.00	0.00	QC8
140	Outsource	10 pcs	11/1/17		0.00	0.00	Outsource4
150	Packaging	10 pcs	11/1/17		0.00	0.00	Packaging2
155	QC	10 pcs	11/1/17		0.00	0.00	QC5
170	QC	10 pcs	11/1/17		0.00	0.00	QC14
180	Packaging	10 pcs	11/1/17		0.00	0.00	Packaging3
190	QC21-SA	10 Ea	11/1/17		0.00	0.00	QC21

Part Op 100 - Cut Blank at 4.500"
Descriptions: 110 - 1-Machine per folio FB190
140 - Issue P/O:

Job Allocations

Operation 90-Start up Operation
Component Part M7075T6B1.000X7.000
Required 4
Inventory 5
Allocated 0
Std Qty 0

Part Specifications

Specifications could not be found.

Plex 10/17/17 1:15 PM dart.Michaud-Febrille.Victoria

1 X 4.5 (4838-2) 3.75 p.
7 X 4.5 5017370 3.75 p. (5035918)

DART AEROSPACE LTD		Work Order:	
Description: Upper Cutter Body, RH		Part Number:	D4838-2
Inspection Dwg: D4838	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.130 x 45°	+/-0.030 x +/-0.5°	0.135 x 45°	✓		Ver	EDG
4.18	+/-0.030	4.175	✓		H.G.	
7.03	+/-0.030	7.025	✓		Ver	EDG
0.60	+/-0.030	0.594	✓		Ver	EDG
0.74	+/-0.030	0.741	✓		Ver	EDG
1.40	+/-0.030	1.399	✓		Ver	EDG
2.44	+/-0.030	2.443	✓		Ver	EDG
R0.25	+/-0.030	R0.25	✓		R.G.	
23.7°	+/-0.5°	23.6°	✓		D.A.G.	
30.2°	+/-0.5°	30.2°	✓		D.A.G.	
0.168	+0.003/-0.000	0.168	✓		D.G.	KT 04
0.263	+0.002/-0.003	0.262	✓		Ver	EDG
0.272	+/-0.010	0.272	✓		Ver	EDG
6.625	+/-0.010	6.623	✓		H.G.	
6.250	+/-0.010	6.250	✓		H.G.	
4.167	+/-0.010	4.166	✓		H.G.	
1.883	+/-0.010	1.882	✓		H.G.	
Ø0.177	+0.005/-0.001	0.177	✓		G.P.	
0.400	+/-0.010	0.400	✓		Ver	EDG
0.360	+/-0.010	0.366	✓		Ver	EDG
4.560	+/-0.010	4.559	✓		Ver	EDG
2.110	+/-0.010	2.110	✓		Ver	EDG
2.400	+/-0.010	2.399	✓		Ver	EDG

Measured by: <i>SL</i>	Checked by:	QC Inspector:
Date: 17/12/23	Date:	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	15.10.14	New Issue	KJ	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO0387

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Ext Price
18	169361	646.9813	Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C Lower Deflector Low Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.9800 Rev. A	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$11.85/pcs	\$142.20
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20	166819	D4838-1	Upper Cutter Body, LH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-1 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$10.95/pcs	\$109.50
21	166821	D4838-2	Upper Cutter Body, RH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed	1/30/17	1 pcs	0 pcs	1 pcs	\$10.95/pcs	\$10.95
22	166822	D4838-2	Upper Cutter Body, RH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed	1/30/17	17 pcs	0 pcs	17 pcs	\$10.95/pcs	\$186.15
23	169560	SWA6A-800A	Connector Bushing -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	1/30/17	6 pcs	0 pcs	6 pcs	\$3.10/pcs	\$18.60
24	169654	SWA6A-700	Wire Clamp -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$7.45/pcs	\$89.40
25	169600	RBT18538-1	Left Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$14.58/pcs	\$29.16



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914458

Date: 22-Ja

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
10 ea	Part: D4838-1 Upper Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22310	Rev: A	PO: PO038727 Line: 20
1 ea	Part: D4838-2 Upper Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22311	Rev: A	PO: PO038727 Line: 21
17 ea	Part: D4838-2 Upper Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22312	Rev: A	PO: PO038727 Line: 22
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>9/21/18</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			

DAS
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3-39